



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D130-1048-141
Job Sheet 198181



Part No: D130-1048-141

Job Qty: 1 pcs

Part Name: EC130 Fwd Crosstube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/23/19

Job Tracking No:

Due Date: 8/2/19

Created By: Jason Leroux

Type: Stock

Description:

Note: DWG D130-1048-141 REV.B/ IIN-D130-1048 REV.C IPP REV:A 18.07.19 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
160	Crosstubes - 1	1 pcs	8/2/19		0.00	0.00	Crosstubes - 1		GP 19-07-26
							Crosstubes - 2		
							Crosstubes - 3		
							Crosstubes - 4		
170	QC 5	1 pcs	8/2/19		0.00	0.00	QC 5 - 10		JUL 31 2019 68 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
171	QC 7	1 pcs	8/2/19		0.00	0.00	QC 7 - 10		
							QC 7 - 13		
							QC 7 - 14		
							QC 7 - 15		
							QC 7 - 17		
							QC 7 - 18		
							QC 7 - 19		
							QC 7 - 2		

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Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S200729



Part: D130-1048-141

Job No: 198181

Serial No/Batch: S200729

Revision: B/C

Inspector:

Exp Date:

Instructions: TC STC SH19-4 Issue 1 Date: 07/26/19

				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	DAS JUL 31 2019 68
				QC 7 - 50	9-89
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
172	Outsource - 2 - NDT per QSI038	1 pcs	8/2/19	SKY002-VC	2 2019-08-02
174	Packaging 2-1 - Receive - B4B	1 pcs	8/2/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B

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176 QC 6	1 pcs	8/2/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
190 Spray Paint - 2 - B4B	1 pcs	8/2/19	0.00 1.00	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
200 QC 14	1 pcs	8/2/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
210 Packaging 3-1 - Stock - B4B	1 pcs	8/2/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	

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9-89

AUG 0 2 2019

A8 19-8-20

DAS
41
9-89

AUG 2 1 2019

A8 19-8-21

				Packaging 3 - 36 - B4B	
215 DC - 1 - B4B	1 pcs	8/2/19	0.00 0.00	DC - 1 - B4B	AUG 2 1 2019
				DC - 2 - B4B	
220 QC 21 - SA	1 pcs	8/2/19	0.00 0.00	QC 21 - SA - 21	AUG 2 1 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op **160** - 1-Remove bending marks longitudinally. ***Use Linemate*** 1-Drill rivet holes in cuff using DT10428 as per DWG Descriptions: sections D-D and E-E. ***Use DT8550 as center support *** 2-Drill and ream holes sections B-B as per DWG using DT10436 3-Drill and ream holes sections C-C as per DWG using DT10436 4-CHAMFER ID 0.06 X- 45° AS PER DWG 5-Debur as per DWG. 6-Grind tube lightly if required to remove any marks left from the drilling process. 7-Alodine tube immediately after grinding

170 - QC5- Inspect part completeness to step on W/O

171 - (QC7-Inspect Chemical Conversion Coat)*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

172 - (Outsource process - NDT per QSI038 4.1) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** ISSUE P/O: _____ Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order NDT C OF C IS REQUIRED

174 - (Receive & Inspect for Damage & Mat'l Certs) Ensure copy of NDT results attached to work order.

176 - (QC6- All purchased or subcontracted products)

190 - *Spray Paint (Spray Paint / NDT Room) **MASK PRIOR TO PRIME AND PAINT AS PER NOTE 9*** ** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** 1- PRIME INSIDE AND OUTSIDE PER QSI005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER) BATCH: 5199127 2- PAINT OUTSIDE SURFACE AS PER QSI005 4.2.2.4 (FLOAT SKIDTUBE PAINT) BATCH: 5204428

200 - (QC14- Inspect Spray Paint)

210 - Identify and pack for shipping as per PPP D130-1048-141 Location: LG050 PPP Rev: _____

215 - (Document Control) Photocopy blue file and create labels as per PPP D130-1048-141 chg 001

220 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D5609-1	EC130 Fwd Crosstube	1 pcs (1 ea)	160-Crosstubes - 1	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
160-Crosstubes - 1	D5609-1	1	13	0

Part Specifications	
Specifications could not be found.	

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K6A 1K7
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Tel (613) 632-5200

PURCHASE ORDER

POHB044190



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044190

PO Date: 8/1/19

Due Date: 8/2/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	198181	D130-1048-141	EC130 Fwd Crosstube : TC STC SH19-4 Issue 1 (Outsource process - NDT per QSI038 4.1) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** ISSUE P/O: _____ Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order NDT C OF C IS REQUIRED	Firmed	-	8/2/19	1 pcs	0 pcs	1 pcs	\$169.00/pcs	\$169.00
							1X	AUG 02 2019			DAS 40 9-89
2	194132	D119-796-141	Fwd Crosstube Installation Without Step (No Hardware) : TC STC SH14-45-Issue 1, FAA STC SR03504NY 15/01/28, EASA STC 10052022 Revision 1 15/02/13, DGCA INDIA LoA 07-09/2011-AED (Part) 15/07/16, BRAZIL STC 2015S07-16 15/07/30, CAAP PHILIPPINES LoA 16/05/11, CHINA VSTC0757 16/07/22, RUSSIA STC CT316-A119 16/08/11, DGAC INDONESIA STC SR025 18/02/19 Outsource2 (Outsource process - NDT per QSI038 4.1) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	8/2/19	1 pcs	0 pcs	1 pcs	\$169.00/pcs	\$169.00
							1X	AUG 02 2019			

Plex 8/2/19 8:57 AM Dart.Guerin.Kimberley



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Hawkesbury, ON
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Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044190



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
194133			1X AUG 0 2 2019	Firmed	-	8/2/19	1 pcs	0 pcs	1 pcs	\$169.00/pcs	\$169.00
194134			1X AUG 0 2 2019	Firmed	-	8/2/19	1 pcs	0 pcs	1 pcs	\$169.00/pcs	\$169.00
194135			1X AUG 0 2 2019	Firmed	-	8/2/19	1 pcs	0 pcs	1 pcs	\$169.00/pcs	\$169.00
Sub Total:							4	0	4		\$676.00
Grand Total:											\$845.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/2/19 8:57 AM Dart.Guerin.Kimberley

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO41275	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: POHB044190 ✓
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 5 CROSSTUBES

ITEM ID: D119-796-141 FWD CROSSTUBE INST. WITHOUT STEPS.

- 1 - WORK ORDER ID#: 194132 ✓
- 2 - WORK ORDER ID#: 194133 ✓
- 3 - WORK ORDER ID#: 194134 ✓
- 4 - WORK ORDER ID#: 194135 ✓

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ITEM ID: D130-1048-141 EC130 FWD CROSSTUBE.

- 5 - WORK ORDER ID#: 198181 ✓

Action Taken:				Date:	Initial/Stamp:	
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-5) AS PER ASTM1417M-16				2 Aug 2019		
NO CRACK FOUND						
PEN ZL-37, MPO23206, CLEANER SKC-S MPO15030, EMU. MPO15896, DEV. MPO23451, UV LIGHT M-20142						
<i>Description</i>	<i>Location</i>	<i>P/N</i>	<i>Qty</i>	<i>Batch</i>	<i>S/N Off</i>	<i>S/N On</i>

RECEIVED

AUG 02 2019

DART AEROSPACE LTD.

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:		ACA/SCA Stamp 	Date: 2 Aug 2019
Name:			